



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D4281-1

Job Sheet 177639



Part No: D4281-1

Job Qty: 15 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/15/18

Job Tracking No:

Created By: Michelle Gagnon-Donovan

Due Date: 5/25/18

Type: SOLD

Description:

Note: DWG REV B IPP rev:A 10.11.18 new issue DD ver:EC IPP rev:B 10.12.02 AS PER DWG REV.A DD ver:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	15 Ea		5/25/18	0.00	0.00	Start Up Waterjet		OK 18/07/06
100	Waterjet	15 pcs		5/25/18	0.00	5.00	Waterjet1		OK 18/07/06
101	QC	15 pcs		5/25/18	0.00	0.00	QC2 Waterjet-4		OK 18/07/06
110	Mill Conv	15 pcs		5/25/18	0.00	3.75	Mill Conv 1		18/07/07
120	QC	15 pcs		5/25/18	0.00	0.00	QC2 Machining-5		18/07/07
140	QC	15 pcs		5/25/18	0.00	0.00	QC8-4		OK 18/07/08
150	HandFinish	15 pcs		5/25/18	0.00	0.66	HandFinish1		SA 18-07-09
160	Powdercoat	15 pcs		5/25/18	0.00	0.73	Powdercoat1		OK 18-07-10
170	QC	15 pcs		5/25/18	0.00	0.00	QC3		38
180	Packaging	15 pcs		5/25/18	0.00	0.00	Packaging3-2		9-89
190	QC21-SA	15 Ea		5/25/18	0.00	0.00	QC21		JUL 11 2018

Part Op 100 - 1-Cut as per Dwg Dwg Rev: B Prog Rev: B 2-Deburr if necessary 3-OPEN HOLES ON DRILL
Descriptions: PRESS AS PER DWG

110 - FACE TO SIZE AS PER DWG

150 - Chemical Conversion Coat per QSI005 4.1

160 - White Gloss (Ref: 4.3.5.1) per QSI005 4.3-Alum POWDER COAT: Start Time: 5:35 Oven

Temperature: 500 Finish Time: 9:25 in 138559.

170 - QC3- Inspect Part Finish

180 - Identify as per dwg & Stock Location:

190 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M6061T6B0.750X03.000	6061-T6 Bar .750 X 3.00	3.9500 ft (.26333 ea)	90-Start up Operation	FM 136200

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M6061T6B0.750X03.000	4	24	0

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

DART
AEROSPACE

Container No: S089537



Part: D4281-1
Job No: 177639
Serial No/Batch: S089537

Revision:
Inspector:
Exp Date:
Instructions:

Date: 07/06/19

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Spacer	0.129Inches + 0.005 - 0.001	0.134 0.128	Diameter	$\phi .128$
2	Spacer	0.250Inches ± 0.030	0.280 0.220		.250
3	Spacer	0.550Inches ± 0.030	0.580 0.520		.550
4	Spacer	0.700Inches ± 0.030	0.730 0.670		.700
5	Spacer	3.160Inches ± 0.030	3.190 3.130		3.160
6	Spacer	2.660Inches ± 0.010	2.670 2.650		2.658
7	Spacer	1.330Inches ± 0.010	1.340 1.320		1.229
8	Spacer	1.900Inches ± 0.010	1.910 1.890		1.898
9	Spacer	0.950Inches ± 0.010	0.960 0.940		.949
10	Spacer	0.889Inches ± 0.010	0.899 0.879		.888
11	Spacer	2.598Inches ± 0.010	2.608 2.588		2.597
12	Spacer	0.866Inches ± 0.010	0.876 0.856		0.865
13	Spacer	2.400Inches ± 0.030	2.430 2.370		2.400
14	Spacer	0.735Inches ± 0.010	0.745 0.725		0.738

Plex 7/5/18 3:14 PM dart.leroux.jason